

shift 20 Sept /

Work Order ID 57263

Monday, September 13, 2010 8:43:00 AM



Page 1

Item ID: D3589-041

Accept



Setup Start



Revision ID:

Item Name: LATCH ASSEMBLY

Stop



Start Date: 3/31/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 4/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3589	Rev B								
100		0.00							



Large Fab

Memo

0.00

Large Fab

1- Form D3589-11, assemble and weld D3589-9 to D3589-11 as per dwg D3589

2- grind weld flush as per dwg D3589

3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589

*** ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS***

4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004
ensure parts fit correctly on jig

A/R Stainless Steel Rod Batch: 108160

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

10.09.21

Quality Control

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Required Date: 4/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S 10/09/21

(4)

130



Small Fab

Memo

0.00

0.00

Epi 10/09/21 (4)

Small Fab

1- Assemble as per dwg

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S 10/09/21

(4)

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Page 3

Item ID: D3589-041

Accept



Setup Start



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Item Name: LATCH ASSEMBLY

Stop



Start Date: 3/31/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 4/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 68Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/9/21 sf

10/9/21 JJ

MF
10-9-21

Picklist Print

Monday, September 13, 2010 8:43:00 AM

Page 1

Work Order ID: 57263



Parent Item: D3589-041



Parent Item Name: LATCH ASSEMBLY

Start Date: 3/31/2010

Required Date: 4/9/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue 08-06-05 DD verified by:ec IPP RevB: revised process as per coss DD 10.01.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD4 	NAS1149DN432J	Purchased	No			130	Each	1,140.000	4	16	 E3/0/08/21		
Washer		4D											
D3589-1 		Manufactured	No			100	Each	6.0000	1	4	 E2 10-9-14		
ARM													
D3589-11 		Manufactured	No			56926	Loc Qty	6	Loc Code	4	 E2 10-9-13		
FWD GUIDE PLATE													
D3589-13 		Manufactured	No			56928	Loc Qty	16	Loc Code	4	 E2 10-9-13		
LUG													
						WA	Loc Qty	20	Loc Code	5	 E2 10-9-13		
						56929		20					

Picklist Print

Monday, September 13, 2010 8:43:00 AM

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Work Order ID: 57263



Parent Item: D3589-041



Parent Item Name: LATCH ASSEMBLY

Start Date: 3/31/2010

Required Date: 4/9/2010

Start Qty: 4.00

Required Qty: 4.00

D3589-15



LINK

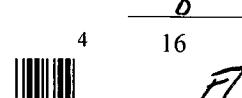
Manufactured No

130 Each

13.0000

2

8



D3589-3



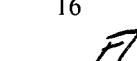
ARM GUIDE

Manufactured No

100 Each

24.0000

4



D3589-7



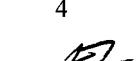
AFT GUIDE PLATE

Manufactured No

100 Each

16.0000

1



D3589-9



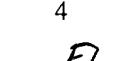
FWD GUIDE PLATE

Manufactured No

100 Each

9.0000

1



MS20392-1C7



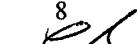
Pin

Purchased No

130 Each

30.0000

2



Location

Loc Qty

Loc Code

WA

9

56933

9

Location

Loc Qty

Loc Code

ST315

30

108521

30

Picklist Print

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Work Order ID: 57263



Parent Item: D3589-041



Parent Item Name: LATCH ASSEMBLY

Start Date: 3/31/2010

Required Date: 4/9/2010

Start Qty: 4.00

Required Qty: 4.00

MS24665-1010

Purchased

No

130

Each

201.0000

2

8



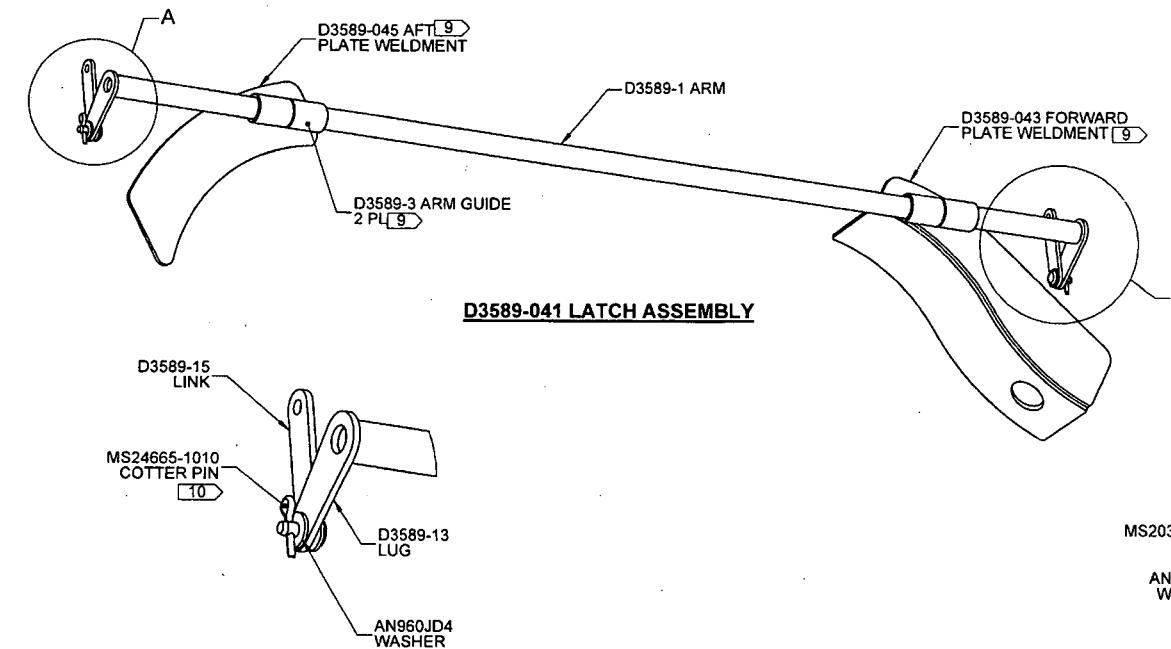
COTTER PIN

Location	Loc Qty	Loc Code
ST309	201	
111359	12	
114405	189	

E30/08/21

8

QTY. -041	P/N	DESCRIPTION
X	D3589-041	LATCH ASSEMBLY
1	D3589-045	AFT PLATE WELDMENT
1	D3589-043	FORWARD PLATE WELDMENT
1	D3589-1	ARM
2	D3589-3	ARM GUIDE
2	D3589-13	LUG
2	D3589-15	LINK
4	AN960JD4	WASHER
2	MS20392-1C7	PIN
2	MS24665-1010	COTTER PIN



DETAIL A: LINK ASSEMBLY DETAIL

SCALE 2X
2 PL

- D3589-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs
 - 8) WELDING: PER DART QSI 004 USING DT9033
 - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
 - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29° WAS 15° (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.		BY	DATE
DESIGN	<i>AB</i>		DART AEROSPACE LTD
DRAWN	<i>AB</i>		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>		REV. B
MFG. APPR.	<i>AB</i>		DRAWING NO.
APPROVED	<i>AB</i>		D3589
DE APPR.	<i>AB</i>		SHEET 1 OF 8
DATE	08.06.25		TITLE
			SCALE
			LATCH ASSEMBLY
			NTS
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RELEASED
08/06/08

8	7	6	5	4	3	2	1																								
 <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th>QTY -043</th> <th>QTY -045</th> <th>P/N</th> <th>DESCRIPTION</th> </tr> </thead> <tbody> <tr> <td>X</td> <td></td> <td>D3589-043</td> <td>FORWARD PLATE WELDMENT</td> </tr> <tr> <td></td> <td>X</td> <td>D3589-045</td> <td>AFT PLATE WELDMENT</td> </tr> <tr> <td>1</td> <td>1</td> <td>D3589-3</td> <td>ARM GUIDE</td> </tr> <tr> <td></td> <td>1</td> <td>D3589-9</td> <td>AFT GUIDE PLATE</td> </tr> <tr> <td>1</td> <td></td> <td>D3589-11</td> <td>FORWARD GUIDE PLATE</td> </tr> </tbody> </table>				QTY -043	QTY -045	P/N	DESCRIPTION	X		D3589-043	FORWARD PLATE WELDMENT		X	D3589-045	AFT PLATE WELDMENT	1	1	D3589-3	ARM GUIDE		1	D3589-9	AFT GUIDE PLATE	1		D3589-11	FORWARD GUIDE PLATE				
QTY -043	QTY -045	P/N	DESCRIPTION																												
X		D3589-043	FORWARD PLATE WELDMENT																												
	X	D3589-045	AFT PLATE WELDMENT																												
1	1	D3589-3	ARM GUIDE																												
	1	D3589-9	AFT GUIDE PLATE																												
1		D3589-11	FORWARD GUIDE PLATE																												
D							D																								
C							C																								
B							B																								
A							A																								
8	7	6	5	4	3	2	1																								

D3589-043 FORWARD PLATE WELDMENT

D3589-045 AFT PLATE WELDMENT

D3589-043/-045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

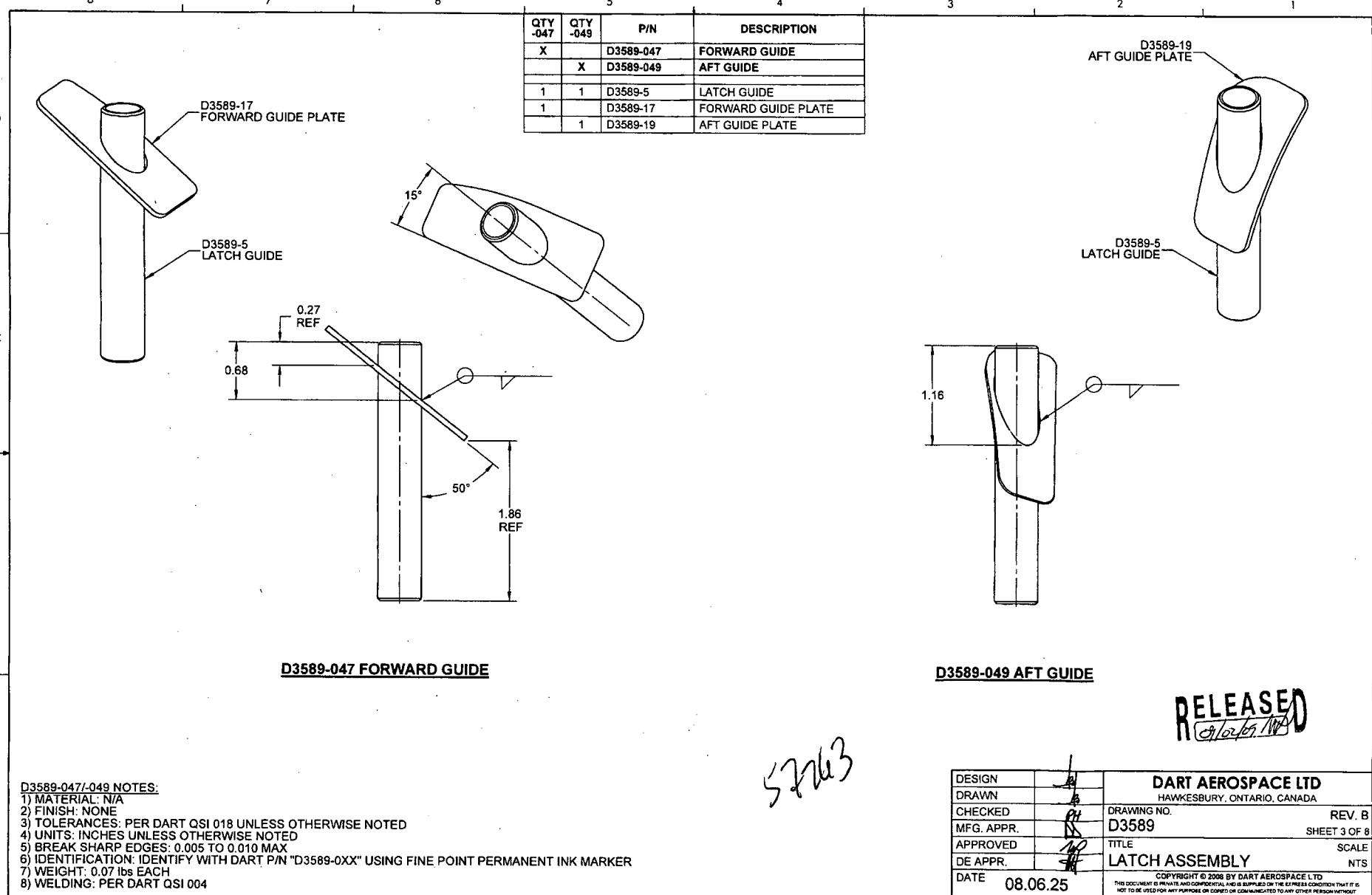
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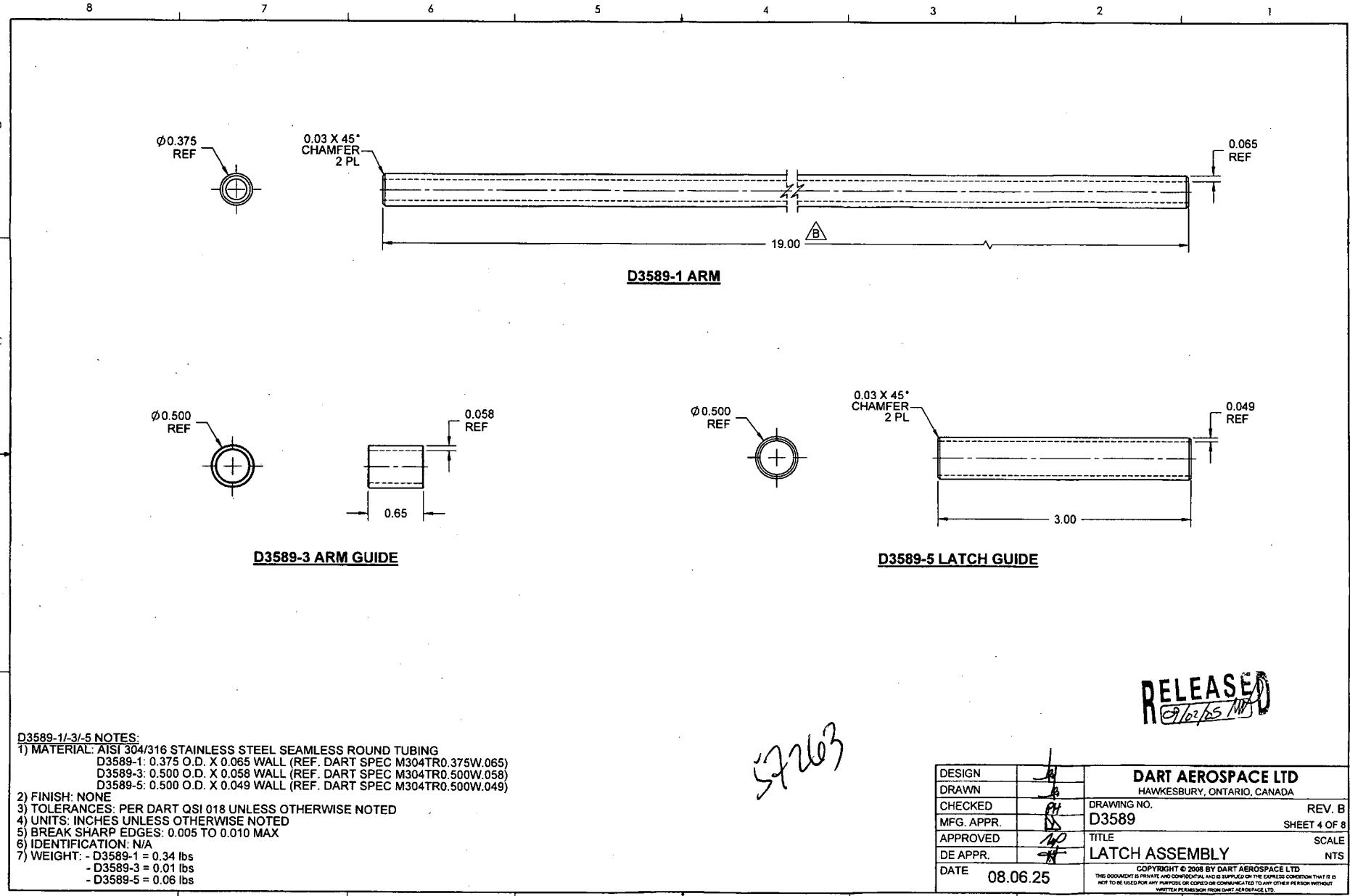
09/03/05 NM

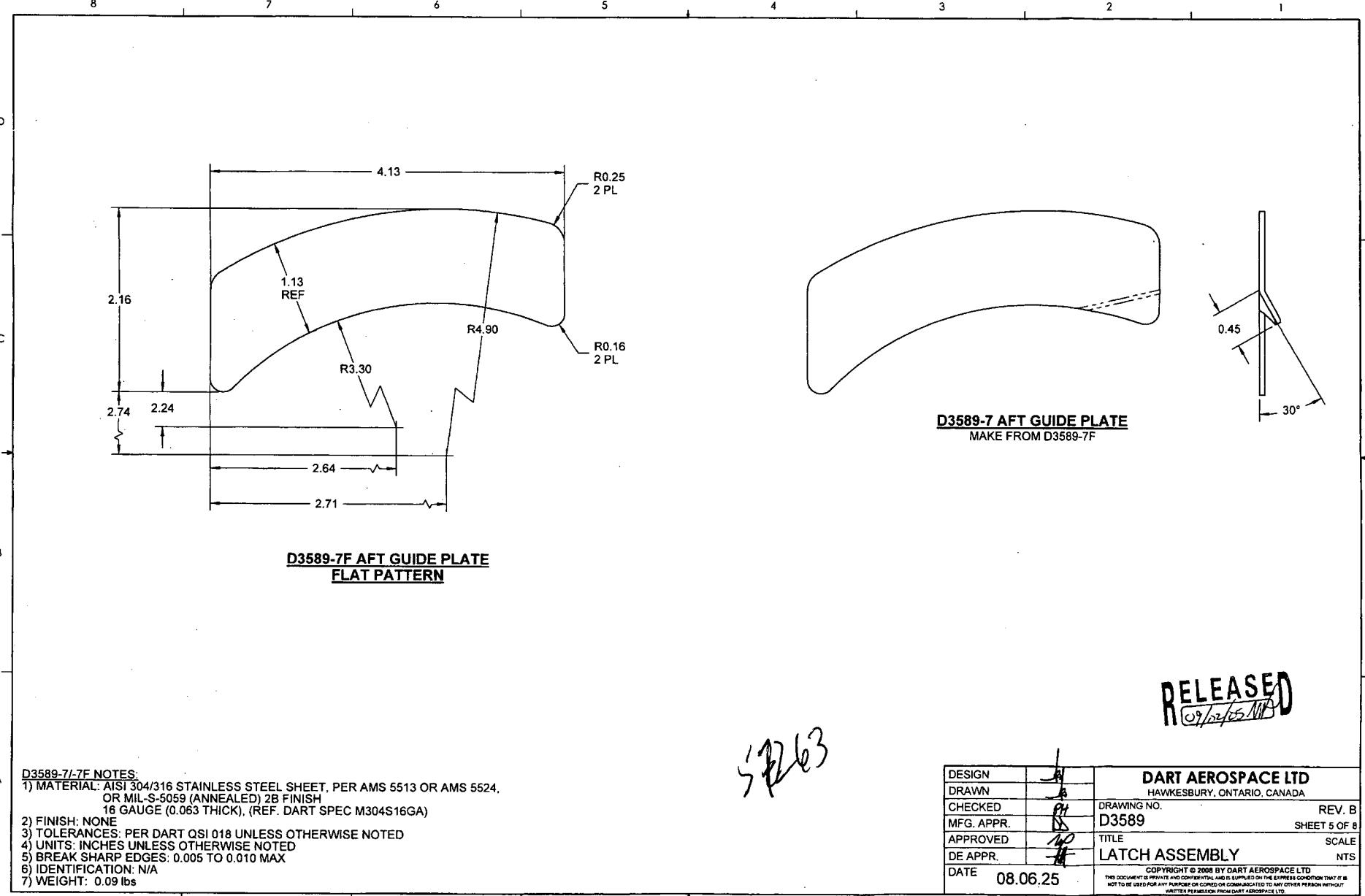
57263

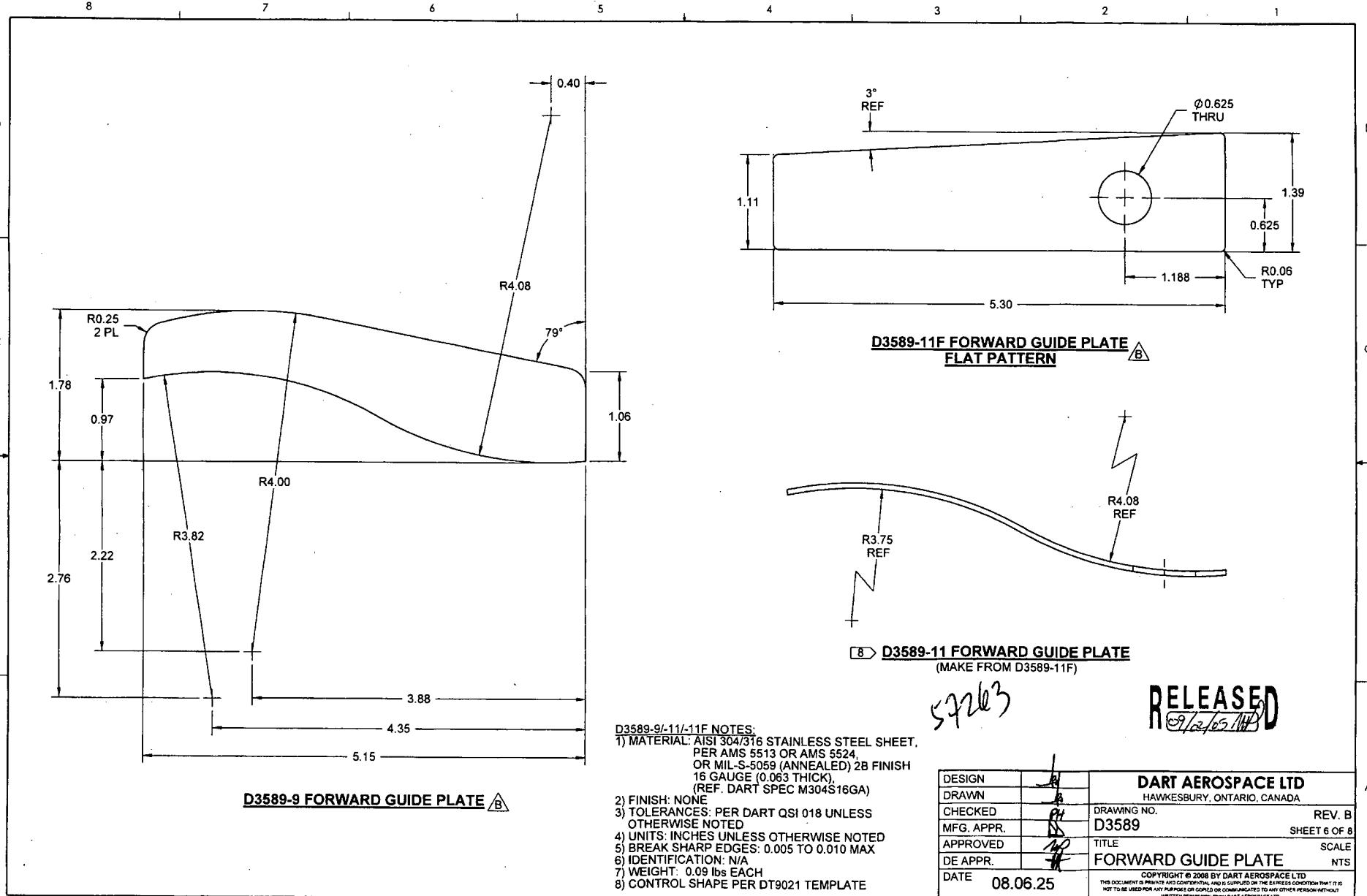
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1	1	1	1
REV. B	DRAWING NO. D3589	SHEET 2 OF 8	
			TITLE LATCH ASSEMBLY
			SCALE NTS
			DATE 08.06.25

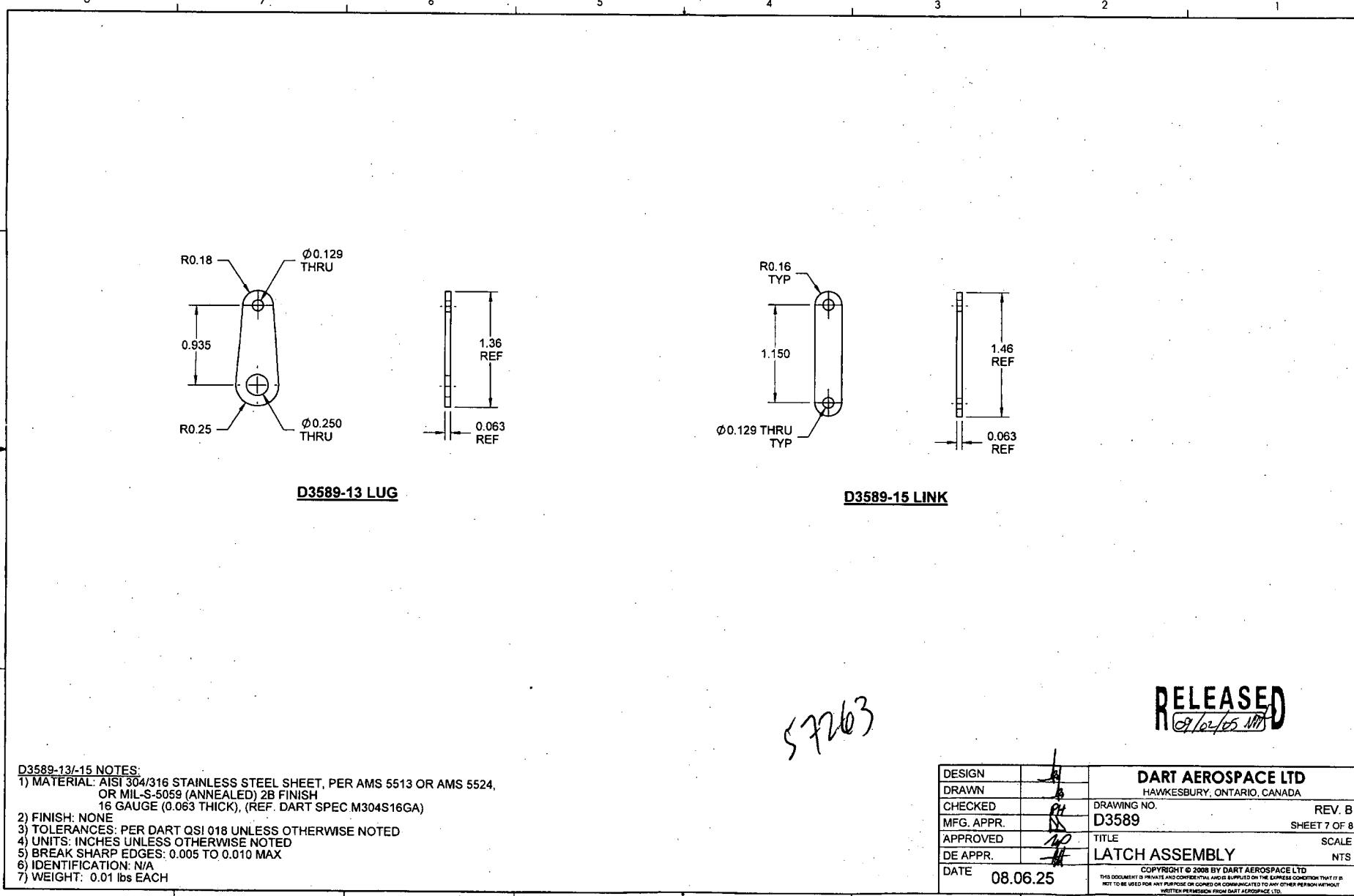
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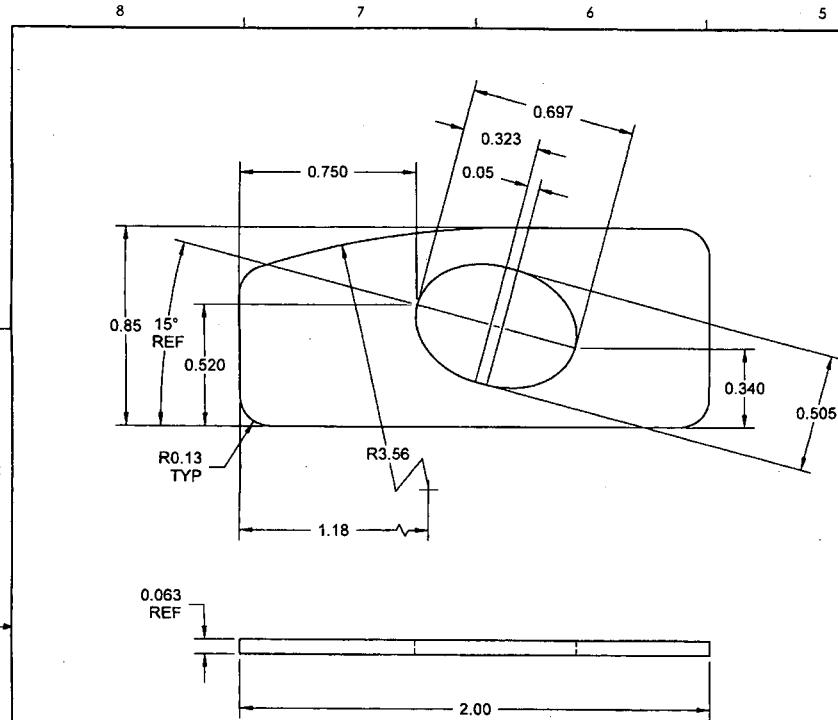




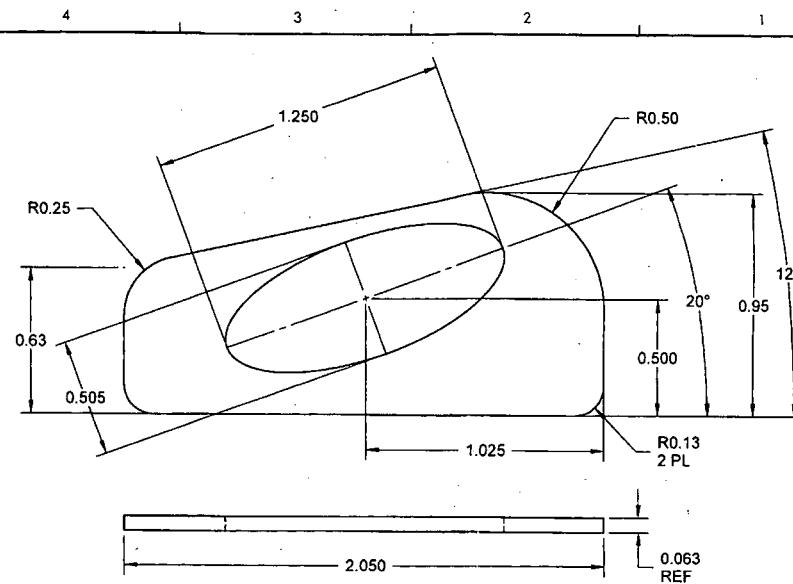




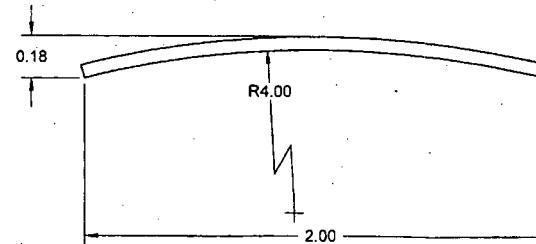
RELEASED
(Signature)



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)

RELEASED
09/02/05

- A **D3589-17/-19/-19F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH, 16 GAUGE (.063 THICK), (REF. DART SPEC M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs EACH

57263

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PY</i>		
MFG. APPR.	<i>PY</i>	REV. B	
APPROVED	<i>PY</i>	DRAWING NO.	
DE APPR.	<i>PY</i>	D3589	SHEET 8 OF 8
		TITLE	LATCH ASSEMBLY
		SCALE	NTS
		DATE	08.06.25

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